

AMENDMENTS TO THE SPECIFICATION WITH MARKINGS TO SHOW CHANGES MADE

Amend the following paragraph(s):

[0026] -- Turning now to the drawing, and in particular to FIG. 1, there is shown a fragmentary cross sectional view of an mold for carrying out a process according to the present invention. The mold is implemented as a positive or compression mold and typically includes a fixed mold platen (not shown) and a moving mold platen 11 in parallel relationship, whereby the mold platen 11 carries a half-mold 7, and the fixed platen carries a half-mold 9. The mold is closed by moving the moving platen 11 toward the fixed platen, thereby forming a cavity 1 between the half-molds 7, 9. The fixed platen normally interacts with a screw (not shown) of an injection unit by which plasticized material is introduced via a sprue channel through the fixed platen into the cavity 1 of the mold. The moving platen 11 is operated by a drive unit which also applies the clamping force. The drive unit may include four hydraulic cylinders for interaction with the moving platen 11. The edge of the cavity 1 is bounded by die inserts 3 which are supported via disk springs 5 by bearings 43 14 or the like, upon the moving platen 11. The dies 3 are so biased by the disk springs 4 as to be supported by the fixed half-mold 9 in the mold parting plane 17.--.

[0036] -- Subsequently, the mold is closed until reaching a residual distending opening 15 and molding the plastic material into a plastic article while applying the clamping force to thereby maintain the plastic material compressed, This step corresponds to the mandatory compression phase, as described hereinafter and shown in FIG. 3.--.

[0037] -- In this process phase, the plastic mass is maintained in compressed state to prevent material shrinkage to lead to sink marks, and a constant pressure profile is maintained and generated by suitably applying the

clamping force. Of course, it is also conceivable to apply a constant clamping force. During the entire compression phase, the clamping movement compensates shrinking plastic material to prevent formation of sink marks on the product surface. Suitably, the dies 3 are so moved to a clamping position as to leave a residual distension opening 15 at the end of the cycle to ensure that the plastic mass is maintained under pressure during the entire cycle.--.